

Date: Monday, 17/11/2008 1:54:35 PM  
User: Julie Dawson

# **Process Sheet**

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206L AFT X-TUBE
<b>Job Number</b> : 43494	
<b>Estimate Number</b> : 10973	
<b>P.O. Number</b> :	<b>Part Number</b> : D206667203BL
<b>This Issue</b> : 17/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D206-667-243 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / /	<b>Drawing Revision</b> :
<b>Previous Run</b> : 43476	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 02/02/2009
<b>Checked &amp; Approved By</b> : <u>JUD 08.11.17</u>	<b>Qty</b> : 1 <b>Um</b> : Each
<b>Comment</b> :	
Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM	
Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec	
Est Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC	

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
<b>Comment:</b> DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D206-667-203 CHG003 <i>509/01/08</i>		
2.0	D206667203TRN	Crosstube Turning Detail
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) CROSSTUBE TURNING DETAIL batch <u>B34774</u> <u>B43529</u> <i>08-12-08</i>		
3.0	BENDING	BENDING MACHINE SKIDTUBES
<b>Comment:</b> BENDING MACHINE Bend tube as per Dwg D206-667-243 using CNC bender program 206L AF and Folio FT <i>08-12-08</i>		
4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
<b>Comment:</b> DIMENSIONAL CHECK OF X-TUBES <i>08-12-08</i>		
5.0	CROSSTUBES	CROSSTUBES RESOURCE 1
<b>Comment:</b> LANDING GEAR RESOURCE 1 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes. 2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 <i>08-12-08</i>		

W/O: ,		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 206L AFT X-TUBE

Job Number: 43494

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243  
Inside of Cuff (Do not engrave on outside of tube)

DD  
MB  
08-12-08

Am/ANM 08-12-09

DD MB 08-12-08

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



ANM 8-12-10



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION.

08/12/11 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/11 (4)

9.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



P/O: 7874 020211/19 (1)



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

PS/14/19 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 206L AFT X-TUBE

Job Number: 43494

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC6  
QC5

DIMENSIONAL CHECK



ml

08 12 19

①



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

12.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2 - GREY

B# 110161

ml 08/01/05 ①

2-

-PAINT DELFLEET BLUE B# 110077

-CLEAR DELFLEET B# 110161

13.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 01-01-06

14.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 42784

RT 08-12-22

15.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 43176

RT 08-12-22

16.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet 110219

RT 08 12 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43494

Part Number: D206667203BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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17.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 08-12-22

18.0	D3595075450	RUBBER CUSHION .75" x 4.50
------	-------------	----------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
RUBBER CUSHION .75" x 4.50

B41108

RT 09-01-06

19.0	D28921	Support
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1 Support 43385

RT 09-01-06

20.0	MS2192022	Clamp(per MIL-DTL-8783C)
------	-----------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22 Clamp 108187

RT 09-01-06

21.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

RT 09-01-06

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

RT 09-01-07

22.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8 09/01/07 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43494

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104679

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109297

26.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M109752

27.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M110363

28.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M109752

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43494

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

509/01/08 @

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

D

9/1/8

SP

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 09/01/09

Job Completion



MF 09-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

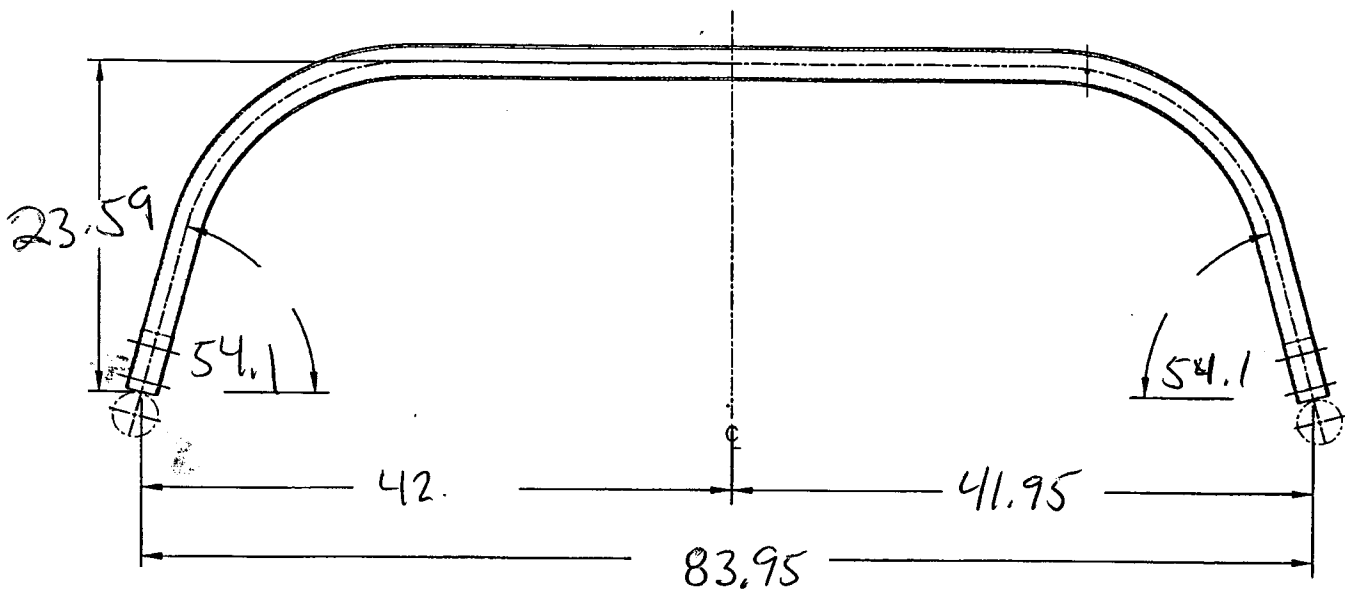
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43494
<b>Description:</b> Crosstube High Aft (206L)		<b>Part Number:</b> D206-667-203
<b>Inspection Dwg:</b> D206-667-243 <b>Rev:</b> B		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	<i>[Signature]</i> 08-12-08
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

Item	Qty -243	Part Number	Description
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
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CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43494

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-243	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

- [12] D2892-1 SUPPORT  
2 PL
- [15] MS21920-22 CLAMP  
4 PL
- [13] D3595-063-450  
RUBBER CUSHION  
4 PL, (UNDER CLAMP)

10.03

A4-2

D206-667-603

B7-2

B2-2

**D206-667-243**  
**ASSEMBLY DETAIL**  
(VIEW LOOKING FWD)

**RELEASED**  
8/11/06 MP

- D2873-043  
NUT PLATE
- MS20601AD4W10  
RIVET, 4 PL
- D2873-045  
NUT PLATE
- MS20601AD4W10  
RIVET, 3 PL
- 90°  
REF

**VIEW A-A:**  
**CUFF DETAIL**  
SCALE 4X

- [13] [15]  
MS21920-22 CLAMP REF
- [12]  
D2892-1 SUPPORT REF

D3595-063-450  
RUBBER CUSHION REF

**FWD**

6°

**SECTION B-B**  
SCALE 5X

- D2873-045  
NUT PLATE
- MS20601AD4W10  
RIVET, 3 PL
- 90°  
REF

**VIEW C-C:**  
**CUFF DETAIL**  
SCALE 4X

- D2873-043  
NUT PLATE
- MS20601AD4W10  
RIVET, 4 PL

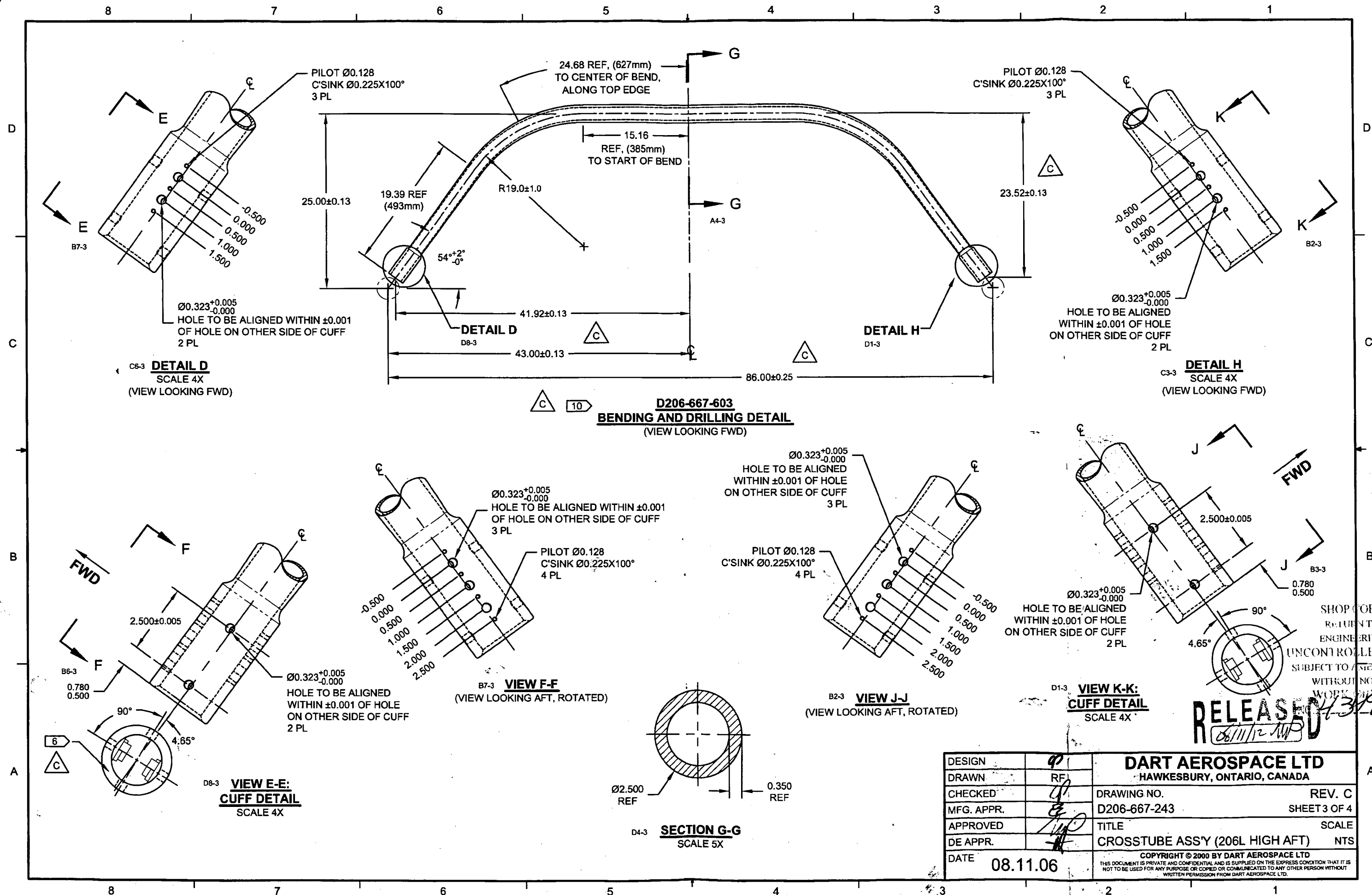
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WORK OF  
NO 4394

DESIGN	40	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D206-667-243	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

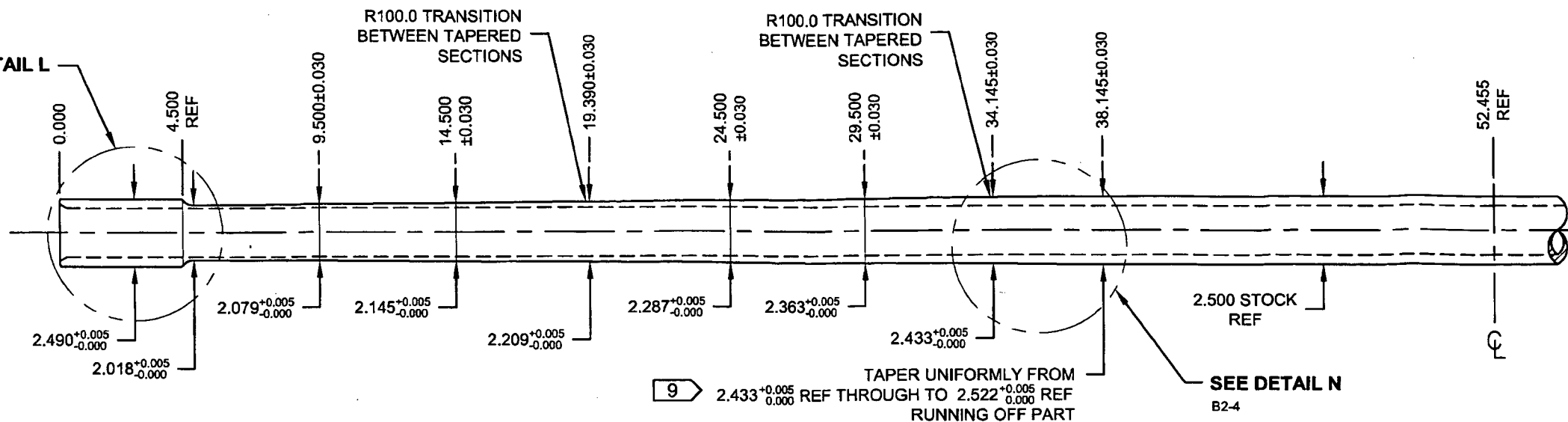




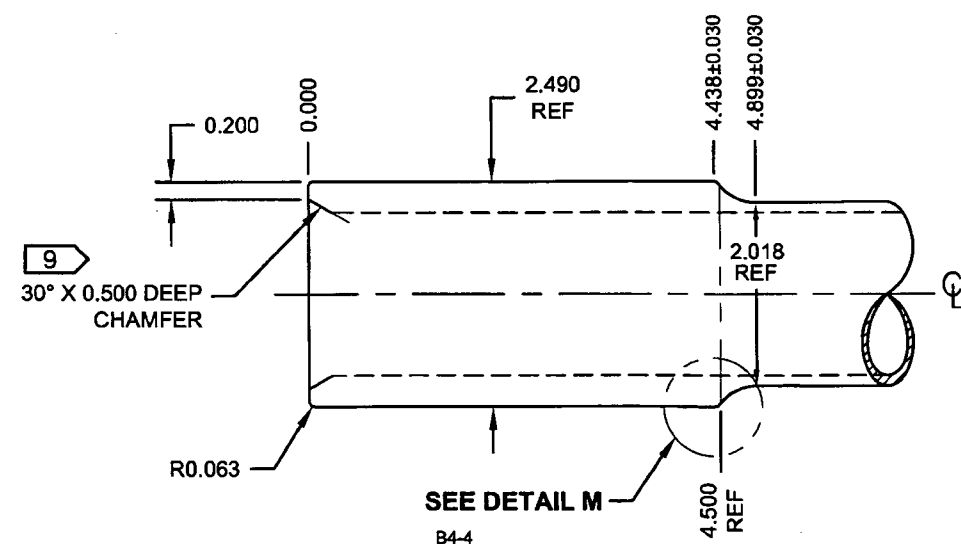




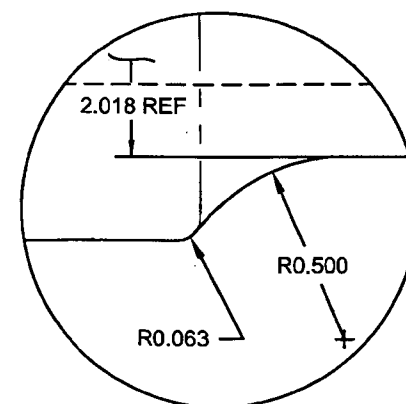
SEE DETAIL L  
B7-4



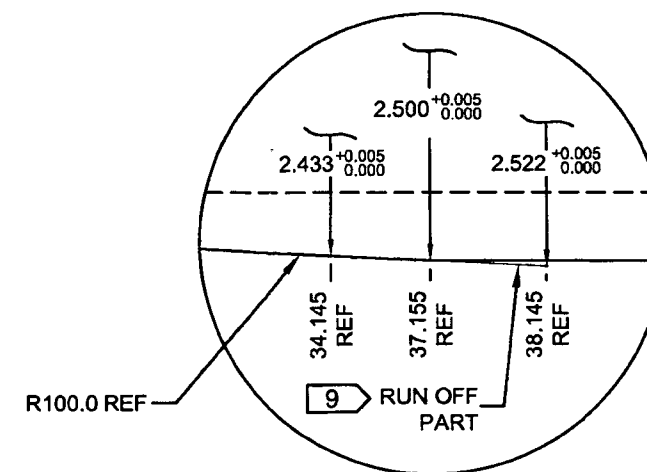
**TURNING DETAIL**



**DETAIL L: CROSSTUBE CUFF**  
NOT TO SCALE



**DETAIL M: CUFF TRANSITION**  
NOT TO SCALE



**DETAIL N: TAPER RUN-OFF**  
NOT TO SCALE

STOP COPY  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 1394

**RELEASED**  
08/11/12

DESIGN	Q	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. C
MFG. APPR.	Q	D206-667-243	SHEET 4 OF 4
APPROVED	Q	TITLE	SCALE
DE APPR.	Q	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





## LIQUID PENETRANT TEST REPORT

P- 09134

PAGE 1 OF 1

CLIENT Dart Aerospace DATE Dec 16, 08 TIME AM ☐ PM ☐  
ATTENTION Linda Lacelle ACUREN JOB NO. 188-08-1656  
ADDRESS 1270 Aberdeen St. POWO No. 7874  
Hawkesbury, Ont, K6A 1K7 WORK LOCATION Hawkesbury  
ACCEPTANCE STD. Asm 1417/Q5103B REV./DATE 2005  
PROJECT 206 L AFT-X-TUBE, High AFT XTUBE 412, 212/205 HIGH FED X-TUBE ASSEMBLY  
ITEM(S) EXAMINED Sob's : 43494, 43475, 43928, 43929, 44133, 44136

JOB DESCRIPTION PROCEDURE NO. LT-0003 REV./DATE TECHNIQUE NO. LT-0003 REV./DATE  
PART NO. D206667203BL D412664203, D212664101 MATERIAL ALODINE ALUM. THICKNESS  
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON  
100% EXTERNAL SURFACE

TEST DETAILS  
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED  
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 8171 ☐ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup> ☐ AMBIENT < 2 fc  
PENETRANT MINIMUM DWELL TIME 30 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE  
PENETRANT REMOVER H<sub>2</sub>O MINIMUM DRY TIME >10 MIN. OTHER CAL FEB 09  
DEVELOPER SKD52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE  
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE  
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL  
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ( <input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)		ACCEPT	REJECT
ITEM	COMMENTS		
13475:		✓	
13474:		✓	
13928:		✓	
13929:		✓	
14133:		✓	
14136:		✓	

Scope of Services  
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.  
Standard of Care  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES  
CLIENT REPRESENTATIVE Eric Downing SIGNATURE  
TECHNICIAN (SIGNATURE): FREDERICK CHAGNON SIGNATURE  
NAME (PRINT): FREDERICK CHAGNON 1<sup>ST</sup> TECHNICIAN  
CGSB LEVEL II SNT LEVEL II CGSB LEVEL II SNT LEVEL  
CGSB REG. No. 10560 CGSB REG. No.  
DTR #  
REPORT REVIEWED BY:  
NAME INITIALS

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

Date: Wednesday, 19/11/2008 9:03:58 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206L AFT X-TUBE
<b>Job Number</b>	: 43494		
<b>Estimate Number</b>	: 10973		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206667203BL
<b>This Issue</b>	: 19/11/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D206-667-243 REV B
<b>First Issue</b>	: 17/11/2008	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 43476	<b>Drawing Revision</b>	:
		<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 02/02/2009
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec Est Rev:H 08-07-18 remove thread masking in step 12 DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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JUD 08-12-05

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

2.0	D206667203TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 CROSSTUBE TURNING DETAIL  
 batch \_\_\_\_\_

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT \_\_\_\_\_

Job Completion

